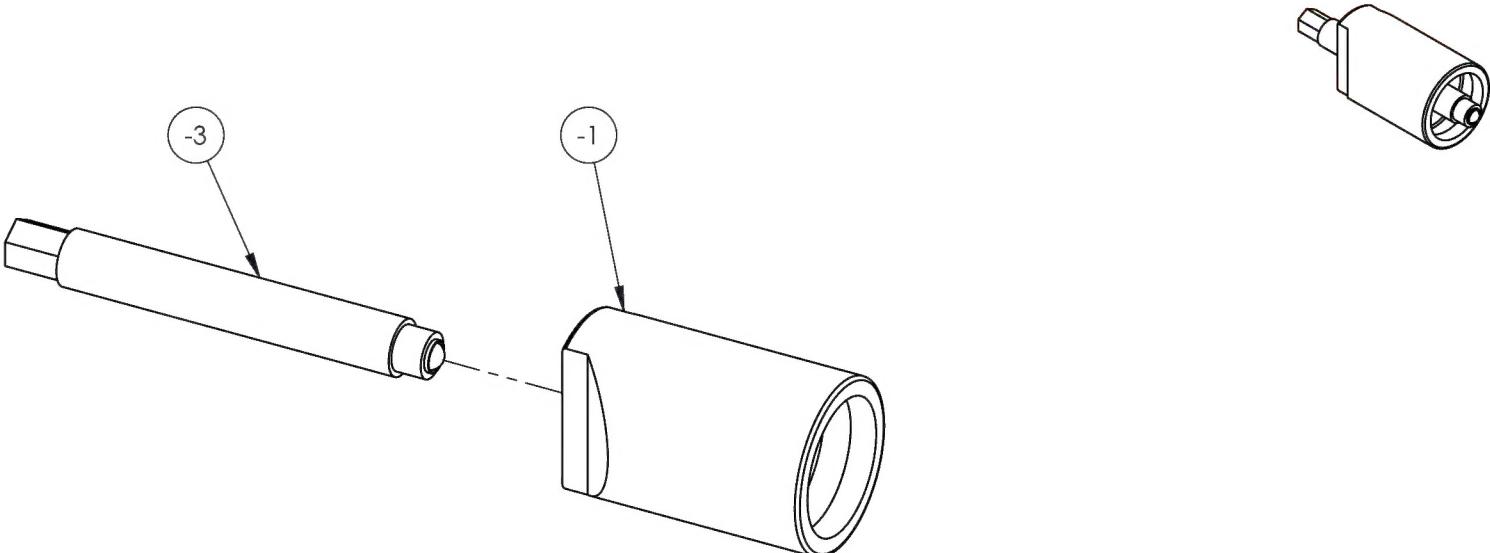


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	9/12/2016	rjc	JAG

SEE ATTACHED DEVIATION



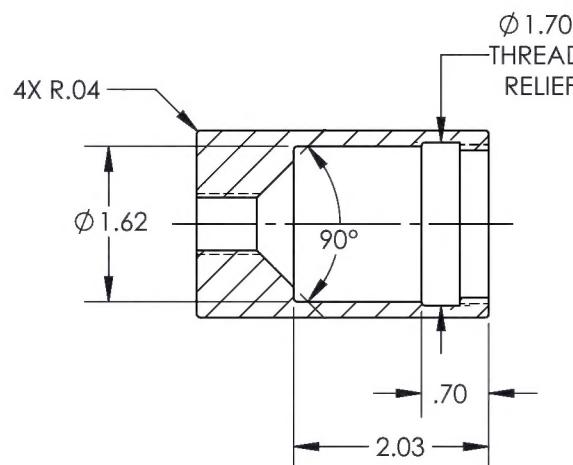
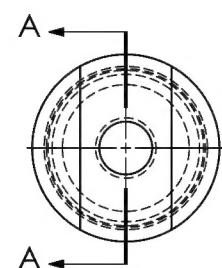
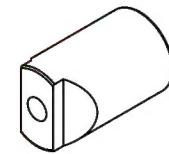
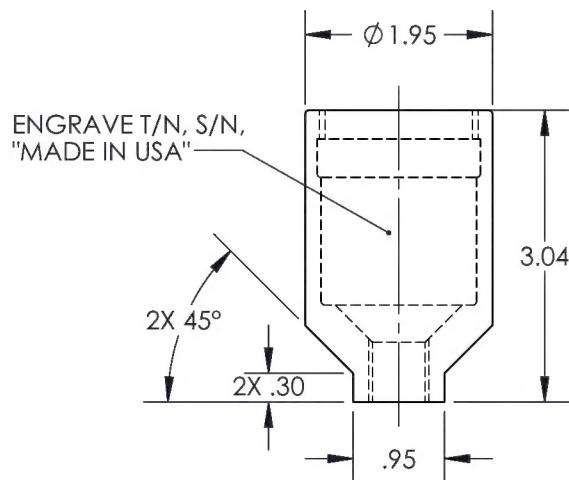
NOTE:
REF. EUROCOPTER T/N 1X56-122-276.

			
TITLE PULLER			
DWG NO. RBE1X56-122-276 REV 1			
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT		XXX $\pm .005$	FRACTIONS $\pm 1/8$
TREAT		XX $\pm .01$	ANGLES $\pm .5^\circ$
FINISH		X $\pm .1$	SURFACES = 125
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED: DUERFELDT		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR: ANDERSON		USED ON MODEL	
QA APPR: LINDSAY		EC145	
APPROVED: GILBERT			
SCALE	1:2	DATE	7/13/2016
		SHEET 1 OF 4	

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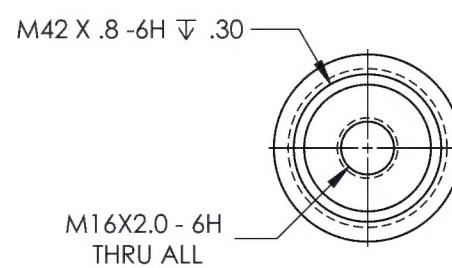
REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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SEE ATTACHED DEVIATION



SECTION A-A

(-1)
HOUSING



DART AEROSPACE	
TITLE	
PULLER	
DWG NO.	RBE1X56-122-276-1
REV	1
MATERIAL 4140/4142	
HEAT RC 28-32	
TREAT	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H145
SCALE 1:2	DATE 7/13/2016
SHEET 2 OF 4	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/8

.XX ± .01 ANGLES ± 5°

.X ± .1 SURFACES = 125 ✓

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

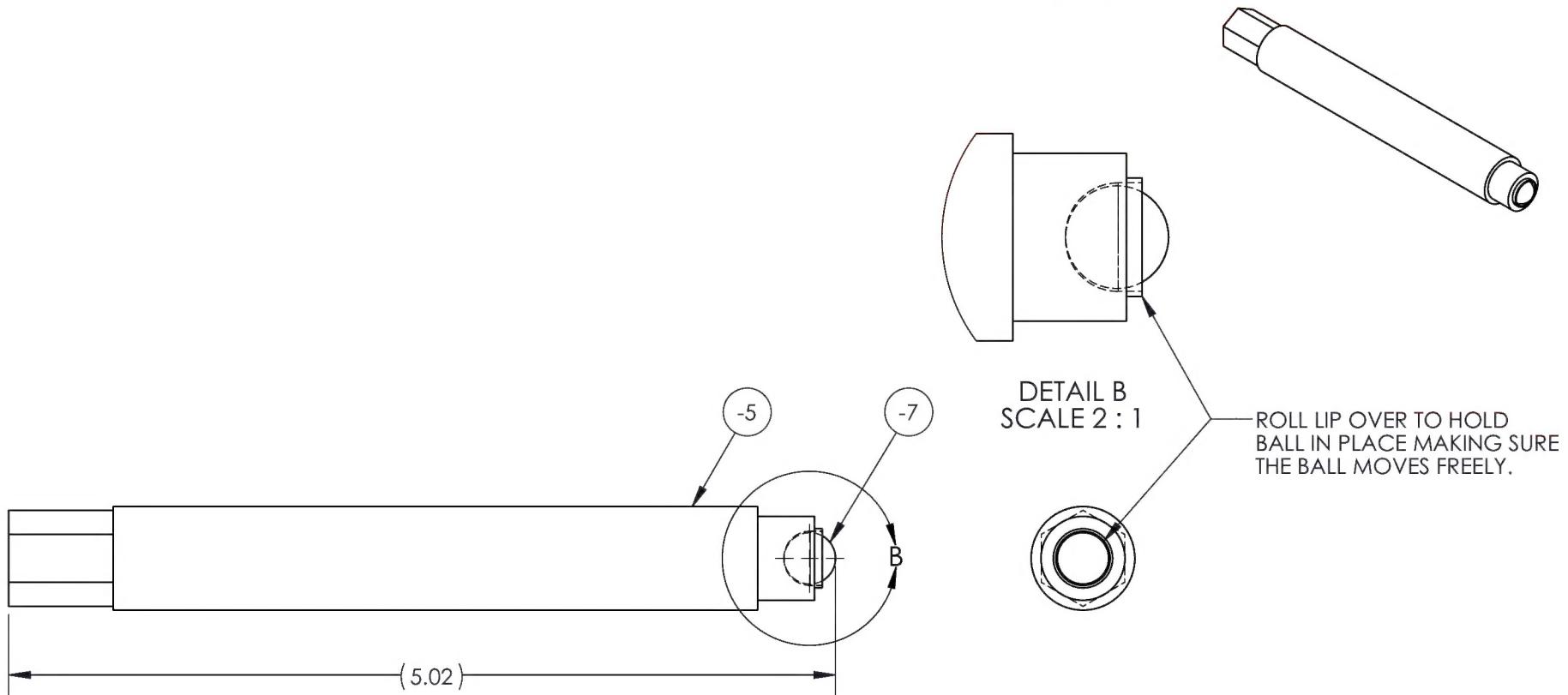
3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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SEE ATTACHED DEVIATION



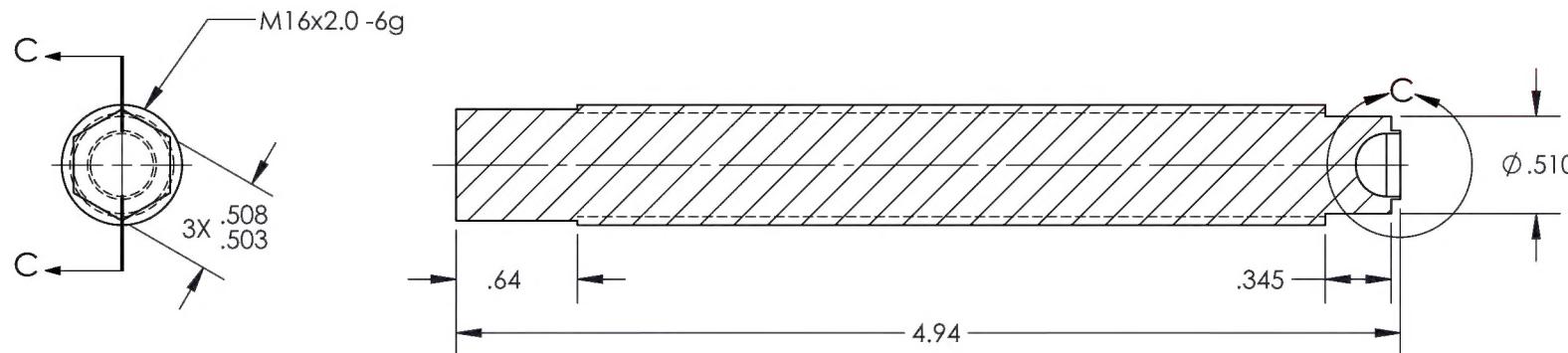
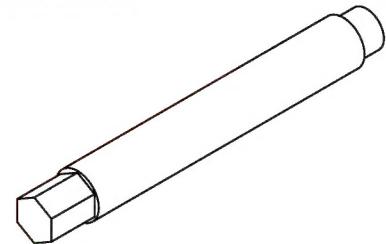
(-3)
BOLT ASSEMBLY

DART AEROSPACE	
TITLE	
PULLER	
DWG NO.	RBE1X56-122-276-3
REV	1
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	EC145
SCALE	1:1
DATE	7/13/2016
SHEET 3 OF 4	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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SEE ATTACHED DEVIATION



DETAIL C
SCALE 2 : 1

(-5)

BOLT

SECTION C-C

DART AEROSPACE	
TITLE	
PULLER	
DWG NO. RBE1X56-122-276-5	
REV 1	
MATERIAL 4140/4142	
HEAT TREAT RC 28-32	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY: CLOUGH	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 7/13/2016
SHEET 4 OF 4	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
X ± .1 SURFACES = 125 ✓
1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL
EC145

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____	DISPOSITION	DEPARTMENT/PROCESS			
Part No. <u>RBE1X56-122-276-5</u> <u>REV. 1</u>	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/>	Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/>	Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/>	Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier Quality <input type="checkbox"/>
Date : _____	Sequence #: _____	QTY Affected : _____			
Description Work Order Deviation		Disposition			
<p>ADDED THREAD RELIEF BETWEEN 0.508 - 0.503 HEX AND M16 x 2.0 - 6g THREAD</p> <p>ADDED 0.04 x 45.0° CMF TO END OF 0.508 - 0.503 HEX</p>		<p>THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED</p>			
Root Cause		FAULT CATEGORY			
Operator <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled <input type="checkbox"/>	Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread <input type="checkbox"/>	
Manufacturing Process <input checked="" type="checkbox"/>	Other/Details:				
Equip/Tooling <input type="checkbox"/>					
Handling/Preservation <input type="checkbox"/>					
Material <input type="checkbox"/>					
Product Improvement <input type="checkbox"/>					
Process Improvement <input type="checkbox"/>					
Human Factors <input type="checkbox"/>					